

9

Date: Thursday, 2/7/2008 11:36:51 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE KIT
 Job Number : 37280
 Estimate Number : 10532
 P.O. Number :
 This Issue : 2/7/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 2/7/2008 Type : SMALL /MED FAB
 Previous Run : 36308
 Written By :
 Checked & Approved By : 080207
 Comment : Est : I 03.01.16 Reformat: Incorporated D205-641-011
 KJ/RF
 Est : J 06-07-25 As per DSI 9344
 JLM
 Est : K 06.11.17 Per K10003 Rev C
 KJ
 Est Rev: L 07.01.12 Document Record for copying bluefile rmv
 KJ

Part Number : K10003
 Drawing Number : K10003
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 2/25/2008 Qty: 10 Um: Each

split 5

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Create White labels only per PPP K10003 CHG 005

08/04/21

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0 D2570 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Bushing

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-----------|
| 24 | D2570 | Bushing | 36450 86K |

37920 154K

4.0 D2571 Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Saddle, Fwd, Out

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 1 | D2571 | Saddle | 37252 8K |

B 37921 210

08/04/21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty

Part Number

Description

Batch

1

D2572

Saddle

37283 yx

B37565 6x

6.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty

Part Number

Description

Batch

1

D2573

Saddle

37284

6x

37884 yx

7.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Saddle, Aft, In

Pick:

Qty

Part Number

Description

Batch

1

D2574

Saddle

37285

8.0

D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

1

D2736-1

Bracket

36330

5x

B37766 5x

9.0

D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

1

D2736-3

Bracket

37154

37154 10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Set Screw

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-----------------------|-------|
| 4 | D2747 | Socket Head Set Screw | 36331 |

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Saddle Spacer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2 | D2876 | Spacer | 33543 |

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Saddle Spacer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2 | D2877 | Spacer | 34818 |

13.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Tow Ring

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------------------------------|
| 1 | D2968-041 | Tow Ring | 36332 1x B31907 4x B33099 5x |

14.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Set Screw

Batch:

28093

15.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Bolt

Pick:

105810

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Machine Or Operation:

Description :

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 16 | AN4-6A | Bolt | |

16.0

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|------------------------|
| 4 | AN4-6A | Bolt | M106277 8X M107063 32X |

17.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 8 | AN4-51A | Bolt | M106662 |

18.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 8 | AN6-12A | Bolt | M106513 |

19.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 320.0000 Each(s)

Washer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 32 | AN960JD416 | Washer | 106780 |

20.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 8 | AN960JD616 | Washer | M106552 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN970-4 Washer M105442

22.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 290.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

29 MS21042L4 Nut (or MS21042-4) M106825

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: H

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

DART

| | | | |
|------------------|----------------|--|------------------------|
| DESIGN # | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED PH | APPROVED # | DRAWING NO. K10003 | REV. C SHEET 1 OF 1 |
| DATE 06.11.07 | | TITLE SADDLE KIT | SCALE NTS |
| A | 00.06.01 | NEW ISSUE | |
| B | 00.11.22 | ADD D2707-041 OPTION | |
| C | 06.11.07 | ADD D3533-1 | |

RELEASED

06.11.13 #

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

| AIRCRAFT | INSTALLATION |
|----------------------|------------------------------|
| BELL 205/210/212/412 | D205-634-011 D205-634-015 |
| BELL 204 | D204-635-011 |

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

| PART NUMBER | K10003 | D205-634-011 D205-634-015 | D204-635-011 |
|--------------------------|--------|------------------------------|--------------|
| D205-641-011 | 1 | 1 | 1 |
| D2570 | 16 | 16 | 16 |
| D2571 | 1 | 1 | 1 |
| D2572 | 1 | 1 | 1 |
| D2573 | 1 | 1 | 1 |
| D2574 | 1 | 1 | 1 |
| D2747 | 4 | 4 | 4 |
| D2876 | 2 | 2 | 2 |
| D2877 | 2 | 2 | 2 |
| D2707-041 (or D2968-041) | 1 | 1 | 1 |
| D3533-1 | 2 | 2 | 2 |
| | | | |
| AN4-51A | 8 | 8 | 8 |
| AN4-6A | 16 | 16 | 16 |
| AN6-12A | 8 | 8 | 8 |
| AN960JD416 | 32 | 32 | 32 |
| AN960JD616 | 8 | 8 | 8 |
| *AN960JD1016 | 1 | 1 | 1 |
| AN970-4 | 1 | 1 | 1 |
| MS21042-4 (OR L4) | 25 | 25 | 25 |

* REQUIRED WITH D2707-041 ONLY

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